

Work Order ID 55225

January 12, 2010 1:28:07 PM



Page 1

Item ID:	D4042-5	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Inboard Rib					
Start Date:	1/12/10	Start Qty: 1.00		Cust Item ID:		
Required Date:	1/25/10	Req'd Qty: 1.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	10-1-12	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4042	PAT PA3	10/01/27							

100		0.00							
Large Fab									
Large Fab	Memo	0.00							
	1- Cut as per dwg D4042								
	2- deburr and remove identification markings								

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

PD 10.01.26

110	QC5- Inspect part completeness to step on W/O	0.00							
QC									
Quality Control	Memo	0.00							

=> 8.10.16.26

(X)

120	Identify as per dwg & Stock Location: <u>Basket</u>	0.00							
Packaging									
Packaging	Memo	0.00							

PD 10.01.26 (1)

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55225

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Item ID: D4042-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Inboard Rib

Start Date: 1/12/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

J.D. Probst
test
10.01.30

MF
10-1-27

POSITIVE RECALL
EFFECTIVE 10.01.18 AUTH U
RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 12, 2010 1:28:11 PM

Work Order ID: 55225



Parent Item: D4042-5



Parent Item Name: Inboard Rib

Start Date: 1/12/10

Required Date: 1/25/10

Comments: IPP RevA: new issue DD 10.01.07 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased	No			100	f	48.4054	5.6137			

304 SQ Tube .75x.75x.049W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

48.4054

103240

1.5816

106604

4.9307

107460

29.2779

109087

12.6152

M113763

PD 10.01.26

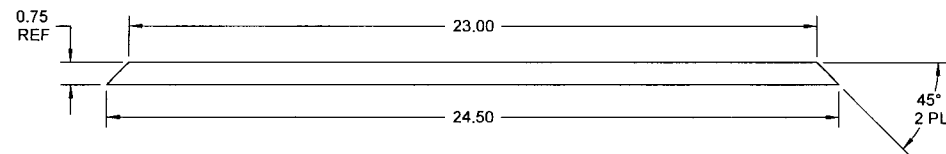
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

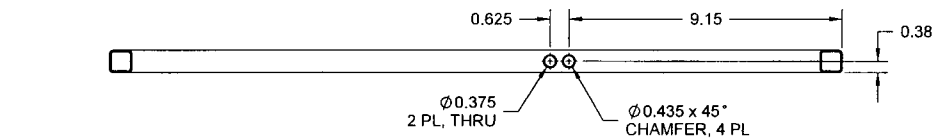
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

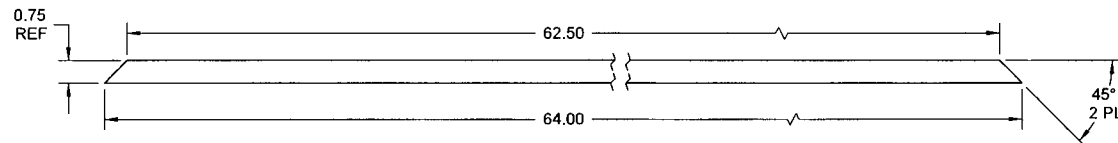
NOTE: Date & initial all entries



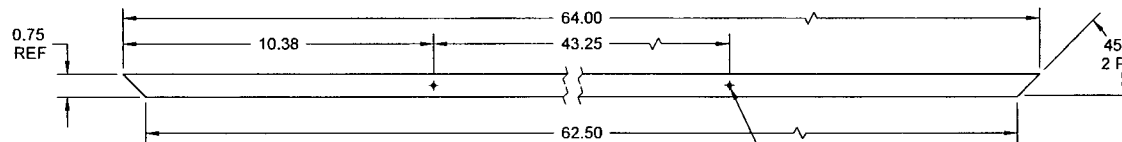
D4042-1 FWD RIB



D4042-3 AFT RIB



D4042-5 RIB



D4042-7 RIB

WLO 55225



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 x 0.75 x 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4042-1: 0.89 lbs
D4042-3: 0.88 lbs
D4042-5: 2.36 lbs
D4042-7: 2.36 lbs

Ø0.129
THRU ONLY
THIS SIDE, 2 PL



PRELIMINARY ISSUE

10.01.18

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4042	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY	NTS
DATE	10.01.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Magna Stainless
5775 Kieran St, Saint-Laurent QC H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

INVOICE

Pg 1 of 1 I022188

SOLD TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY , ON
K6A 1K7

SHIP TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY , ON
K6A 1K7

MTR:Y

INVOICE DATE:	01/25/10
ORDER DATE:	01/19/10
SHIP DATE:	01/25/10
ORDER NUMBER:	W024119
PURCHASE ORDER:	P011060

Currency	Sales Person	Ship Via	F.O.B.	Terms
CANADIAN DOLLARS	ERYCK BLAIS	NIR:R-557065-1	PREPAID	NET 30 DAYS

Ln	Back Ordered	Ordered	Unit	Description	Shipped	Price Per	Value
		15	PC	STAINLESS - FT 304 MF 3/4" SQ X .049 X 20' L035630 15 PC/300 FT	15 UN	65.00	975.00
RECEIVED JAN 28 2010							

01/26/10 13:25:05

PST Exmp No:EXEMPT

Merchandise:	975.00
Surcharges:	
No Tax Costs:	
GST	48.75
Total Due:	1,023.75

Title to the goods sent out on this invoice remains with Magna Stainless Div of CSM ULC until such time as this invoice has been paid in full. Unless otherwise noted terms are 30 days. Interest accrues on all overdue accounts at the rate of 1.5% per month compounded monthly.

Q.S.T. # 1213236471
G.S.T. # 881565899 RT0001

Jan 25 10 01:56p

002/002

p.3

PHOENIX TUBE COMPANY, INC.
Manufacturer of Stainless Ornamental and Structural Tubing
CERTIFICATION OF TEST

Sold To: MAGNA STAINLESS INC.
5775 RUE KIERAN

SAINT-LAURENT
CAN

QC H4S

Ship To: MAGNA STAINLESS INC.
5775 RUE KIERAN

SAINT-LAURENT
CAN

QC H4S

CUSTOMER ORDER#: PO08691

DATE SHIPPED: 02/23/10

SIZE: 3/4SQ X 18 GA AW

SOURCE: USA D

VENDOR: NAS

Specification:

ASTM A554-08a

NO WELD REPAIR

Phone# 3391211

ORDER#: 209402

QTY SHIPPED: 300.0

GRADE: 304

HEAT#: 3DK8

TEST REPORT#: TR007424

Report Date: 11/28/07

Ext:

WELD: HF

WELDED / MILL-FINISH

OK P 10.01.26

PO08691

MERCURY IS NOT USED BY US AS AN ALLOYING MATERIAL NOR IS METALLIC MERCURY HANDLED IN THE VICINITY OF OUR PROCESSING LINES. WE ARE NOT PRESENTLY AWARE OF ANY MERCURY CONTAMINATION.

Chemical Analysis											
C	MN	P	S	SI	CR	NI	MO	CU	CO	N2	
.058	1.564	.028	.015	.267	18.363	8.14	.256	.298	0	.042	

Physical Analysis						
Hardness	YIELD		TENSILE		OTHER	
	PSI	MPA	PSI	MPA	Percent EL	Percent RA
RB 86	49780	0	99490	0	54.1	0

THE CHEMICAL ANALYSES ARE CORRECT AS CONTAINED IN OUR CORPORATE RECORDS.
PHYSICAL PROPERTIES ARE DETERMINED WHILE MATERIAL IS IN STRIP FORM.
Melted & Manufactured in the USA FAR BAA complies, DFARS BAA complies, FAR TAA complies

CERTIFIED BY:

Sancti

1185 WIN DR, BETHLEHEM, PA., 18017 - (610) 865-5337
FAX NUMBER: 610-865-4073

Sq. mill finish